

Dart Aerospace Ltd.

Date: Tuesday, 18/09/2008 2:38:42 PM  
 User: Linda Lacelle

## Process Sheet

SPLIT - 1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212 DETAIL PARTS
Job Number	: 42033 - \		
Estimate Number	: 13228		
P.O. Number	:	Part Number	: D2127251937
This Issue	: 18/09/2008 S.O. No. :	Drawing Number	: D212-725-1 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 16/09/2008 Type : PURCHASED PARTS	Drawing Revision	:
Previous Run	: 42032	Material	: N/A
Written By	: <u>W</u>	Due Date	: 23/09/2008 Qty: <u>1</u> Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-09-16 New Issue LL		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:

Machine Or Operation:

Description:

10

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 711.7 to Cimtube ltee  
 Make per drwg D212-725-1 Rev. E

ship to supplier:

1 x AN818-10J nut B m1052061 x MS20819-10J sleeve B m105206

C208/09/16

⑤



2.0

AN81810J

nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
 nut

m105206

C208/09/16

⑤

3.0

MS2081910J

sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
 sleeve

m105206

C208/09/16

⑤

4.0

D2127251937

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)  
 tube

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR

C208/10/20 ①

Date: Tuesday, 16/09/2008 2:38:43 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 DETAIL PARTS

Job Number: 42033

Part Number: D2127251937

Job Number:



Seq. #:

Machine Or Operation:

Description:

TRANSIT DAMAGE  
ENSURE C OF C ATTACHED

C208110120

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT LEVEL 5

RT 08.10.28

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Identify with P/N and B/N using a fine point marker

Location: \_\_\_\_\_

RT 08.10.28

C208110120 x1 send to Roberto 08/10/2008



8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/30

Job Completion



POSITIVE RECALL

EFFECTIVE 08/10/20 AUTH

RELEASED DATE 08.10.29

Date: Tuesday, 16/09/2008 2:38:42 PM  
 User: Linda Lacelle

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 212 DETAIL PARTS
Job Number : 42033 - \	
Estimate Number : 13228	
P.O. Number :	Part Number : D2127251937
This Issue : 16/09/2008 S.O. No. :	Drawing Number : D212-725-1 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 16/09/2008 Type : PURCHASED PARTS	Drawing Revision :
Previous Run : 42032	Material : N/A
Written By : <u>                    </u>	Due Date : 23/09/2008 Qty: <u>5</u> Um: Each
Checked & Approved By : <u>                    </u>	
Comment : Est Rev:A 08-09-16 New Issue LL	

## Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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## Comment: PURCHASING

Issue P/O: 7167 to Cimtube ltee  
 Make per drwg D212-725-1 Rev. E

ship to supplier:

1 x AN818-10J nut B m105206  
 1 x MS20819-10J sleeve B m105206

C208/09/116

⑤



2.0	AN81810J	nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 nut m105206

C208/09/115 ⑤

3.0	MS2081910J	sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 sleeve m105206

C208/09/115 ⑤

4.0	D2127251937	tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
 tube

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

RECEIVE AND INSPECT FOR

C208/10/20 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 16/09/2008 2:38:43 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 DETAIL PARTS

Job Number: 42033

Part Number: D2127251937

Job Number:



Seq. #:

Machine Or Operation:

Description :

TRANSIT DAMAGE  
ENSURE C OF C ATTACHED

C208/10/20

①

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT LEVEL 5

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Identify with P/N and B/N using a fine point marker

Location: \_\_\_\_\_

C208/10/20 x1 send to Roberto

POSITIVE  
RECALL

08/10/20 feder

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

L2008/10/29

Job Completion



POSITIVE RECALL

EFFECTIVE 08/10/20 AUTH

RELEASED

DATE

08/10/29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

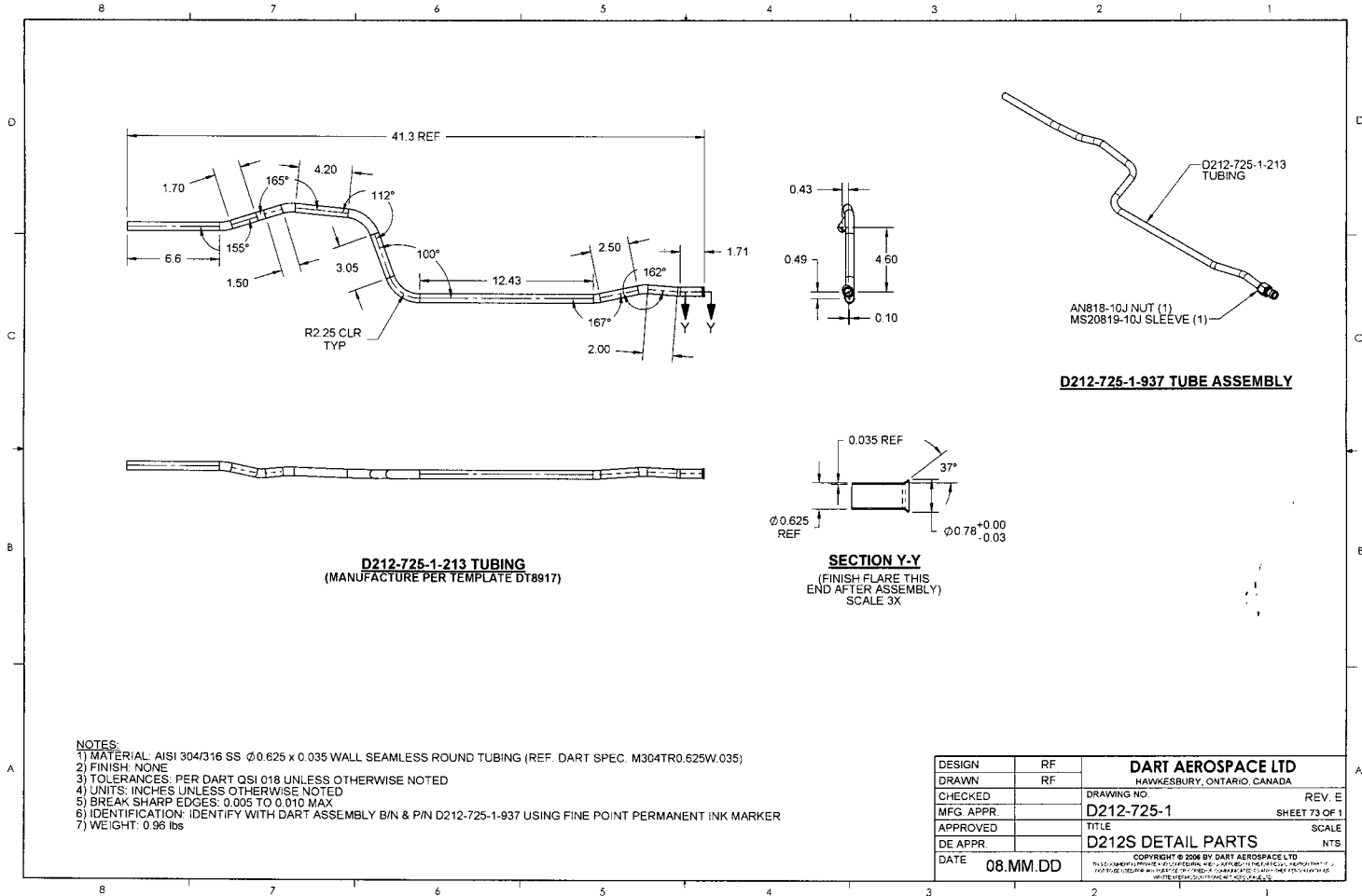
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

S 73



PRELIMINARY ISSUE

W/O 42033

PRELIMINARY

CLIENT: Page 1 of 1  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.

HAWKSBURY  
ON K6A 1K7  
EXPED. A/TO :  
SAME

M-100435

**CINTUBE** LTEE/LTD

☒ 333 BOUL. ST-JOSEPH, BUILDING # 10 ☐ 1250 MATHESON BLVD. EAS  
LACHINE, QUEBEC MISSISSAUGA, ONTARIO  
H8S 2K9 L4W 1R2  
TEL: (514) 634-3592 TEL: (905) 625-1900  
FAX: (514) 636-3336 / 8625 FAX: (905) 625-1500

Rep: JASON ROBINSON

CINTUBE

BON. LIVR RELACHE  
M-100435  
PACK. SLIP RELEASE

DATE: 16-Sep-08  
COMMANDE #: 7167  
ORDER #:

CLIENT NO. MAT'L PAR / MAT'L BY REFERENCE  
MDAR72 CINTUBE & CLIENT

MODE DE PAIEMENT / TERMS OF PAYMENT  
C.O.D. (VISA - VOIR CLAIRES)

CONTACT PHONE #: (613) 632-9577 EXT. #:  
FAX #: (613) 632-1053

TRANSPORT  
PUROLATOR COLLECT #7684382

DATE LIV. / DELIV. DATE  
1 A/TO 2 SEM. / WKS

CONTACT  
CHANTAL LAVOIE

QUANT	EXP.	DIMENSION / SIZE	EP / WALL	DESCRIP. MAT'L. / MAT'L DESCRIP.	DEG.	RAY. / RAD.	TANGENTE / TANGENT	INSTRUCTIONS
5	1	0.625 OD	0.035	PART NO. DART D212-725-1 S73 SMLS TUBE SS/304L ✓	8 BENDS		SEE DRWG: D212-725-1 S73	FINAL CUT & FLARE ONE END
5	1	0.5 OD	0.035	PART NO. DART D212-725-1 S68 SMLS TUBE SS/304L ✓ <i>Oct 8 11/20</i>	6 BENDS		SEE DRWG: D212-725-1 S68	FINAL CUT & FLARE ONE END
2	2			TWO COPIES OF MILL TEST REPORTS				
2	2			TWO COPIES OF LETTER OF COMPLIANCE				

Notes:

CATEGORIE ISO  
ISO CATEGORY

1 2 3  

ASME

EXPEDIE PAR / SHIPPED BY

DATE CLIENT AVIS. / ADV.:

CERTIFICAT D'ANALYSE  
MILL TEST CERTIFICATE

OUI  
YES ☒

LETTRE DE CONFORMITE  
LETTER OF COMPLIANCE

OUI  
YES ☒

CONTACT:

PAR/BY:

DATE: Oct 17/08

CLIENT:

DATE:

SENT WITH SHIPMENT *Oct. 17/08*

Q/C



CINTRAGE DE PRÉCISION, DE TUBES, TUYAUX, CORNIÈRES, POUTRES,  
PROFILÉS EN "U", ET SERPENTINS.  
MANUFACTURIER DE GÉNÉRATRICE À VAPEUR, ÉLÉMENT CHAUFFANT,  
RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISEUR ETC.  
PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS.  
MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,  
WASTE HEAT RECOVERY UNITS, ECONOMIZERS.

333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H8S 2K9  
TÉLÉPHONE: (514) 364-6426 FAX NO: (514) 636-3336

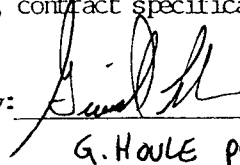
## LETRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE LTD Date: OCT. 17/08  
N° de commande du client/Customer order No: 7167  
Notre n° de feuille de route/Our order No: 100435  
Notre n° de dessin/Our drawing No: —  
Description/Customer drawing No: D212-725-1 S68, D212-725-1 S73  
Nom de la piece/Part Name: P/N D212-725-1-203, P/N D212-725-1-213  
ONE PIECE OF EACH

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by:



G. HOULE pour B. GUERBURY

Directeur des services techniques/Technical Services Director

Pour la Compagnie Cintube Ltée/On behalf of Cintube Ltd.

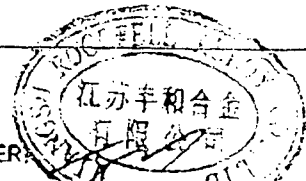
# ROCKWELL ALLOY CO., LTD

## MATERIAL TEST CERTIFICATE

ISO9001 CERTIFICATE (Certificate No.: 3200/97541)

DATE OF ISSUE: MAR.03.2006

CLIENT: DART AEROSPACE  
 ORDER NO.: 100435  
 DATE: 07.17/08  
 BY: [Signature]  
 DATE: MAR.03.2006

CUSTOMER: NORCA INDUSTRIAL CO.,LLC P.O.#31214							CERTIFICATE NO. 2006-03-04 ORDER NO. : 530/001411						
DESCRIPTION : STAINLESS STEEL SEAMLESS TUBING							GRADE : TP304/TP304L						
CONDITION : COLD DRAWN /A & P / PLAIN END/ O.D. POLISHED 220GRIT..							HEAT NO. : 2G152						
CHEMICAL CONTENTS (WT%)													
ELEMENTS		C	Mn	P	S	Si	Ni	Cr	Mo	Ti			
SPECIFICATION		≤0.035	≤2.00	≤0.040	≤0.030	≤1.00	8.00-13.00	18.00-20.00					
RESULTS (LADLE)		0.025	1.88	0.026	0.008	0.30	9.15	18.24					
PHYSICAL PROPERTIES													
Dimensions				Bundle No.	Pieces	Weight (kg)	0.2%Y.S.	T.S.	EL	FLARING TEST	FLATTENING TEST	HARDNESS	HYDROSTATIC TEST
Item	O.D. (inch)	W.T (inch)	Length (feet)				(Psi)	(Psi)	(%)			(HRB)	
1	5/8	0.035	20	0601-32	55	116	44950	90625	50	GOOD	GOOD	70	1793
2	1/2	0.035	20	0601-36	842	1300	43500	87000	55	GOOD	GOOD	71	2242
TOTAL					897	1416							
REMARKS: AS PER ASTM A259-04 A213-04b/SA213 WALL THICKNESS TOLERANCE AS PER AVERAGE WALL IN COMPLIANCE TO NACE MRO175-2002 & EN10204-3.1.B SOLUTION TREATMENT CONDITIONS:1050°Cx1.5m/min MATERIAL FREE FROM MERCURY CONTAMINATION NO WELD REPAIR WAS PERFORMED COUNTRY OF ORIGIN: CHINA							1.WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND THE TEST RESULTS ARE IN COMPLIANCE WITH THE TERMS OF THE PURCHASE ORDER OR CONTRACT. 2.THE CERTIFICATE SHALL NOT BE REPRODUCED, EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE COMPANY.						
							 MANAGER: [Signature]						

**L Lacelle**

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**From:** Roberto Fuentes [rfuentes@dartaero.com]  
**Sent:** October 28, 2008 8:55 AM  
**To:** 'L Lacelle'  
**Subject:** RE: tubes

There all 3 tubes are ok. I will send to you today template and the previous w/o. I will call you in few minutes.

Roberto

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**From:** L Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** Tuesday, October 28, 2008 5:34 AM  
**To:** 'Roberto Fuentes'  
**Subject:** tubes

Hi Roberto,  
Any news on the tubes???

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

28/10/2008